

Date: Wednesday, 07/01/2009 1:36:56 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 84 BRACKET
Job Number : 44478	
Estimate Number : 11035	
P.O. Number :	Part Number : D28032
This Issue : 07/01/2009 S.O. No. :	Drawing Number : D2803 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 34032	Material :
Written By :	Due Date : 30/01/2009
Checked & Approved By : <u>JLD 09.01.09</u>	Qty : 4 Um : Each
Comment : Est. A 00.11.06 New Issue EC	
Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM	
Est Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .500 x 10.00
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Comment: Qty.: 2.0125 f(s)/Unit Total : 8.0501 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch 09288 IB 9-1-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8533

Dwg Rev: B

Prog Rev: B

IB 9-1-12

(4)

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

88 09/01/20

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 1:36:56 PM
User: * Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 44478

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-1-23

(14)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Pc 9/01/23 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/23

Job Completion



MF 09-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

44478

DART AEROSPACE LTD		Work Order: 24478
Description: Bracket		Part Number: D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.757	✓			
1.420	+/-0.001	1.420	✓			
Ø0.191	+0.005/-0.000	Ø0.191	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
Ø0.507 x 0.250	+0.000/-0.001	Ø0.506 x 0.250	✓			
12.411	+/-0.010	12.411	✓			
6.933	+/-0.010	6.932	✓			
0.250	+/-0.010	0.250	✓			
0.875	+0.000/-0.001	0.874	✓			
0.250	+0.000/-0.005	0.250	✓			
0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.125	✓			
0.500	+/-0.010	0.500	✓			
0.125	+/-0.010	0.125	✓			
0.188	+/-0.010	0.188	✓			
0.562	+/-0.010	0.561	✓			
0.125	+/-0.010	0.125	✓			

Measured by: <i>mmf</i>	Audited by: <i>JS</i>	Prototype Approval:	N/A
Date: 09/01/17	Date: 09/01/20	Date:	N/A

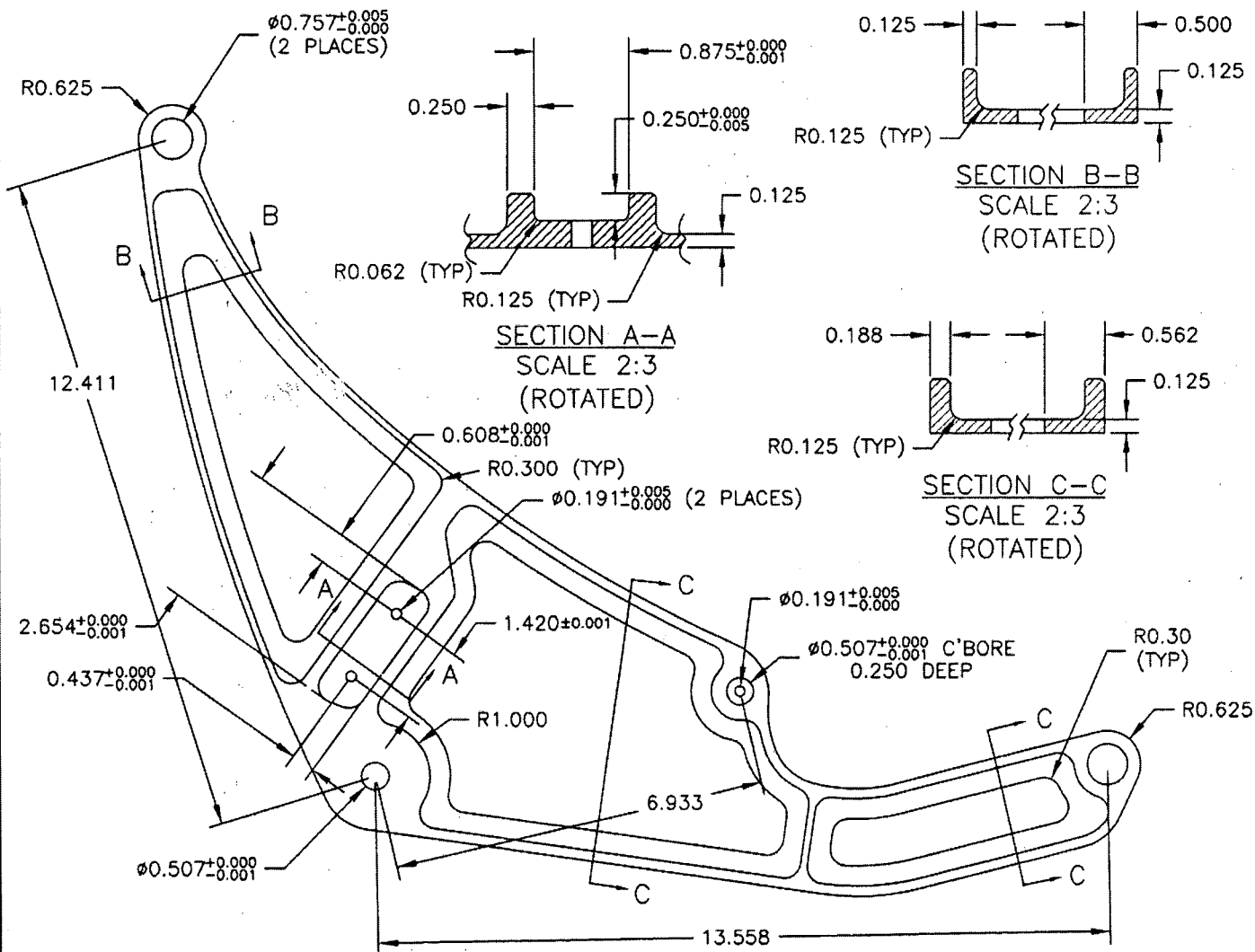
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	<i>DD</i>



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

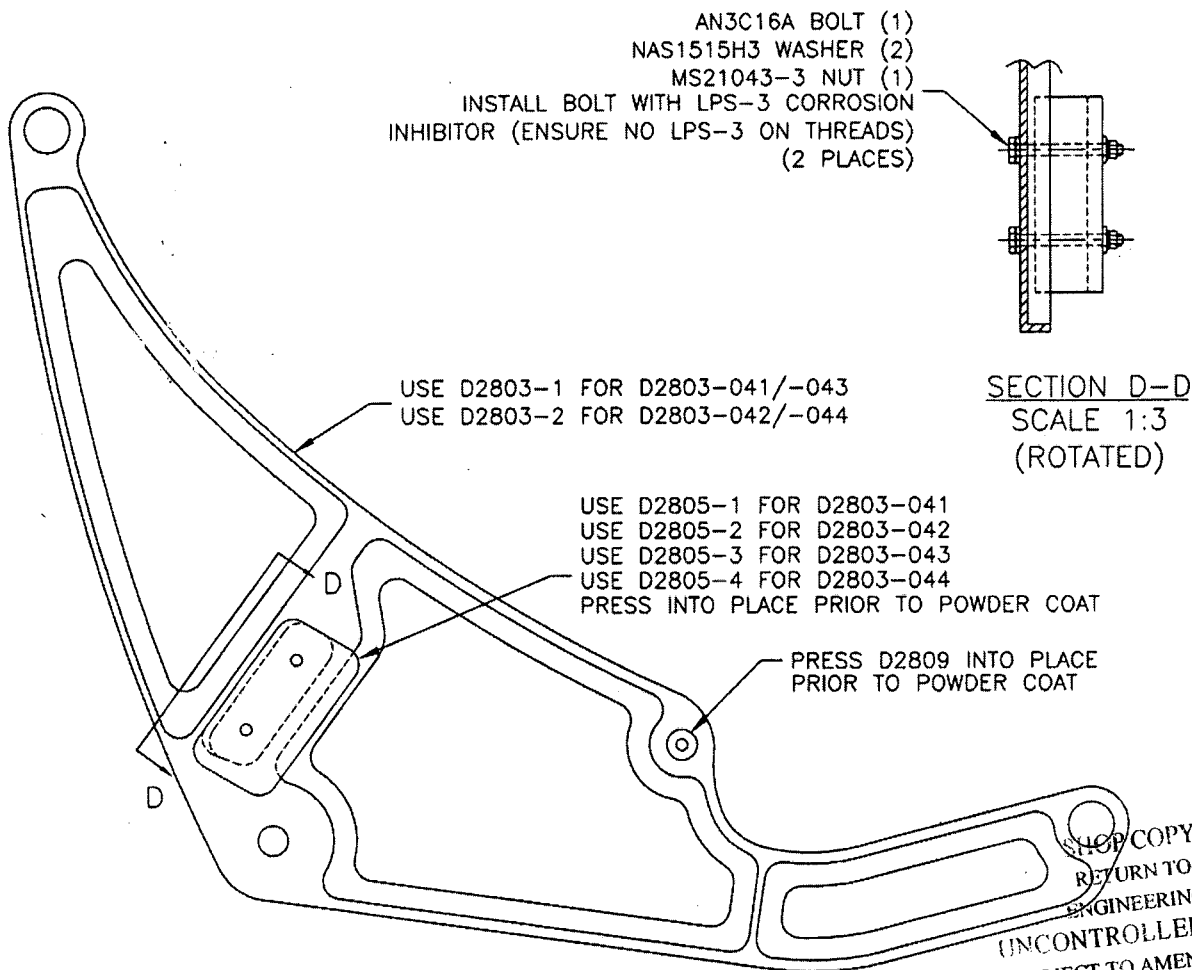
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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